

Work Order ID 163172***163172***

Page 1

Thursday, June 22, 2017 10:20:22 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

DAS

Date: JUN 22 2017 Tooling:

Date:

Stop

NR2

QC:

21

Date:

SPC (Y/N):

Date:

9-89

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750-042

G

D3492

E

DAS
6
9-89

AUG 11 2017

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle:

89.8°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
27
9-89

AUG 15 2017

B# 163172 x1 xRH

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.15							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch <i>m13658/m136920</i>								
	9- Grind welds flush as per Dwg D2750								
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<i>1</i>			<i>DAS</i> <i>38</i> <i>9-89</i> <i>JUL 04 2017</i>
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<i>1</i>			<i>DAS</i> <i>38</i> <i>9-89</i> <i>JUL 04 2017</i>

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1 17-07-06

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Start Date: 6/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.93							
Skidtubes	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.					1	0	17-07-06	JXL
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>M137127</u> exp. date: <u>17-09-26</u>								
	ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>m136920</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

> 9.20 HR

2017/07/07
BE

> BE 17-07-10

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo 0.00

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.02

VERIFY C'BOARD IS GOOD

DAS
38
9-89

JUL 13 2017

DAS
38
9-89

JUL 13 2017

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Item ID: D350-636-012 **Accept** ***N900040100*** **Setup Start** ***NS1***
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Start Date: 6/22/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 7/5/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.41				(X1)	/		201707
200 *200* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>137195</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>138058</u>	0.00 0.43				1			DAS 41 9-89 AUG 02 2017
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Inspect for foreign object per QSI 024	0.00 0.00				VRH	d	ell	12/08/10 DAS 15 9-89

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Start Date: 6/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Assemble as per dwg HandFinishing	0.00							
230	HandFinish								
Hand Finishing	Memo	1.11							
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M137946</u> EXP DATE: <u>18/03</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M135477</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M133690</u> <u>RTU 598 M137797 Exp 18/05</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC								
Quality Control	Memo	0.02							

XIRH 20170810
BEB

1 DAS
38
9-88
AUG 11 2017

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop *NS2*

Start Date: 6/22/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.01

Packaging

1 AUG 14 2017 *[Signature]* DAS 28 9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.03

Quality Control

DAS
27
9-89

AUG 15 2017

270

Identify as per dwg & Stock Location:

0.00

270

Packaging

Packaging

0.00

Packaging

Memo

Package as per PPP D350-636-012
Location : FG072

DAS 27 9-89 DAS 28 9-89 AUG 16 2017

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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.10

Quality Control

DAS
21
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AUG 16 2017

DAS
21
9-89

AUG 16 2017

Picklist Print

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Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY:DD
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT-RH

Manufactured

No

110

Each

5.0000

1

1

D2600-3-BENT-RH

Extrusion Bent RH

**

BE17-06-27

Location

Loc Qty

Loc Code

LG002

5

158774

5

D2744

Manufactured

No

110

Each

20.0000

1

1

D2744

Cap

**

BE170627

Location

Loc Qty

Loc Code

LG001

20

159371

10

161732

10

D2739

Manufactured

No

160

Each

11.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG002

11

159936

3

161380

8

2017/07/07

AP

Picklist Print

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D350-636-012

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

172.0000

8

8

D2743

Crossbolt Spacer

**

BE 17-07-10

Location

Loc Qty

Loc Code

LG001

172

159308

62

160400

110

8

D3490-3

Manufactured No

160

Each

83.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 17-07-10

Location

Loc Qty

Loc Code

LG001

83

160393

83

4

D3490-1

Manufactured No

160

Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 17-07-10

Location

Loc Qty

Loc Code

LG001

95

160394

95

4

D3631-1

Manufactured No

230

Each

159.0000

8

8

D3631-1

Washer

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

18

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

20.0000

1

1

D3791-1

Wearpad

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP002

20

(X1)

158753

10

161928

10

D3793-3

Manufactured No

230

Each

29.0000

1

1

D3793-3

Wearplate Aft

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP002

29

(X1)

159397

4

159871

25

MS21043-6

Purchased No

230

Each

72.0000

4

4

MS21043-6

NUT

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

20

(X4)

103693

20

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

15.0000 1 1

D3794-1

Gasket Fwd

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

***B163934**

15

142770

1

150417

2

159376

12

(X1)

NAS1611-010

Purchased No

230 Each

203.0000 8 8

NAS1611-010

O-RING

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

***M137963**

203

m134955

7

m135603

8

m136182

4

m136836

84

m137587

100

(X8)

D2741

Manufactured No

250 Each

47.0000 1 1

D2741

Replacement Blade

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

37

132981

14

158915

23

1

AUG 14 2017

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

Washer

**

2017/08/10 BEB.

Location

Loc Qty

Loc Code

FG

40

X4

102472

40

FP001

359

m127831

20

m134508

3

m135600

2

m136263

4

m137361

330

ST266

4

m130726

4

NAS1611-013

Purchased

No

230

Each

174.0000

8

8

NAS1611-013

O-Ring

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

174

m137963

174

m137333

X8

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

147.0000

4

4

AN3C6A

Bolt

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

*M138040

10

122416

10

FP001

21

m136295

4

m136781

17

OVER002

96

m137361

96

ST350

20

m128704

18

m132767

2

(X4)

NAS1149C0832R

Purchased

No

230

Each

49.0000

1

1

NAS1149C0832R

Washer

**

BEB 2017/08/10

Location

Loc Qty

Loc Code

FP001

49

m135536

49

(X1)

D3536-25

Manufactured

No

230

Each

27.0000

1

1

D3536-25

Gasket Center

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

3

95328

3

FP001

24

146747

2

159368

4

162506

18

(X1)

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

13.0000

1

1

D3794-3

Gasket Aft

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

*B163320

13

159369

12

159924

1

AN3C5A

Purchased

No

230

Each

928.0000

34

34

AN3C5A

Bolt

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

OVER002

200

M137710

200

ST350

66

M135442

66

x34

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

11

79833

1

88562

10

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

D3535-25

Manufactured No

230

Each

18.0000

1

1

D3535-25

Wearplate Center

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FG

1

148669

1

FP002

17

159879

7

161915

10

D3492-3

Manufactured No

230

Each

218.0000

8

8

D3492-3

Plug

**

2017/08/10 BEB

Location

Loc Qty

Loc Code

FP001

218

159296

136

162347

82

Thursday, June 22, 2017 10:20:25 AM

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Page 9

Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

4,974.000

38

38

NAS1149C0332R

WASHER

**

2017/08/10 BEB.

Location

Loc Qty

Loc Code

FP001

*M137951

1470

m137597

1470

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

(x38)

D3488-042

Manufactured

No

230

Each

3.0000

1

1

D3488-042

Blade Fitting RH

**

2017/08/10 BEB.

Location

Loc Qty

Loc Code

FP001

*B162379

3

158787

3

(K1)

Picklist Print

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Page 10

Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 AELS8-1032-225 Purchased No

230 Each 2,629.000 38 38

AI S4-1032-225

Rivnut

** 2017/08/10 BEB.

Location	Loc Qty	Loc Code
FG	25	(X38)
M134975	20	
M135998	5	
FP001	2204	
M135603	40	
M135920	38	
M135998	2115	
M136265	11	
ST556	400	
M136579	400	

D3492-1 Manufactured No

230 Each 144.0000 8 8

D3492-1

Plug

** 2017/08/10 BEB.

Location	Loc Qty	Loc Code
FP001	144	(X8)
158389	1	
159298	63	
161306	80	

D3793-1 Manufactured No

230 Each 26.0000 1 1

D3793-1

Wearplate Fwd

** 2017/08/10 BEB.

Location	Loc Qty	Loc Code
FP002	26	(A1)
159358	4	
159874	22	

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Page 11

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Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A	Purchased	No	230	Each	124.0000	1	1
AN8C35A						**	<u>2017/08/10 BEB.</u>
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	3	(X)
121275	3	
FP001	121	
m133336	1	
m134130	1	
m134133	7	
m137203	112	

MS21083C8	Purchased	No	230	Each	63.0000	1	1
MS21083C8						**	<u>2017/08/10 BEB</u>
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	18	(X)
m137412	18	
ST297	45	
m137361	25	
m137820	20	

D2745	Manufactured	No	230	Each	182.0000	8	8
D2745						**	<u>2017/08/10 BEB.</u>
Bushing							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	*B163474	(18)
159297	82	
161760	100	

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Picklist Print

Thursday, June 22, 2017 10:20:25 AM

Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

AN6C44A

Bolt

**

2017/08/10 BEB.

Location

Loc Qty

Loc Code

FP001

78

m132556

78

over009

250

m137055

250

ST333

48

m136658

48

D3532-1

Manufactured

No

250

Each

45.0000

2

2

D3532-1

Spacer

**

DAS
28
9-89

AUG 14 2017

Location

Loc Qty

Loc Code

ST038

45

159312

45

MS21083C8

Purchased

No

250

Each

63.0000

2

2

MS21083C8

Nut

**

DAS
28
9-89

AUG 14 2017

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

DAS
27
9-89

Picklist Print

Page 13

Thursday, June 22, 2017 10:20:25 AM

Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

264.0000

2

2

NAS1149D0863.J

Washer

**

AUG 14 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

46

125484

46

ST260a

100

125635

100

ST263

118

125268

118

2

D3493-1

Manufactured

No

250

Each

39.0000

2

2

D3493-1

Washer

**

AUG 14 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST037

29

159305

9

161754

20

2

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

Page 14

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Work Order ID: 163172

163172

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

302.0000

2

2

AN8C21A

**

AUG 14 2017

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

over004

217

m137162

217

ST332

81

m136262

1

m137162

80

2

DAS
28
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 163172 MJS
1706-22

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2013-08-13
WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN	MM		
CHECKED	MM		
MFG. APPR.	MM		
APPROVED	MM		
DE APPR.	MM		
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

TITLE

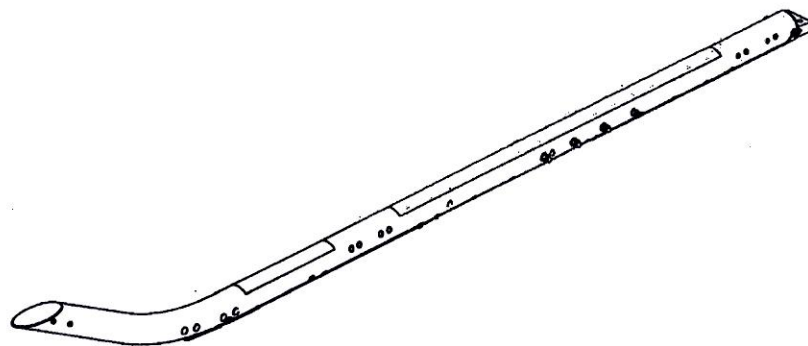
350 SKIDTUBE ASSEMBLY

SCALE

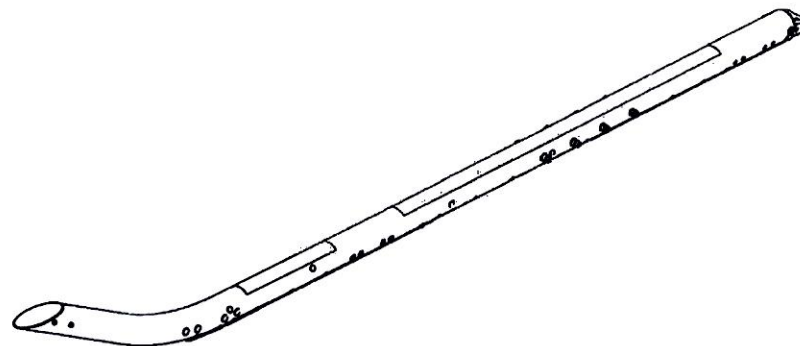
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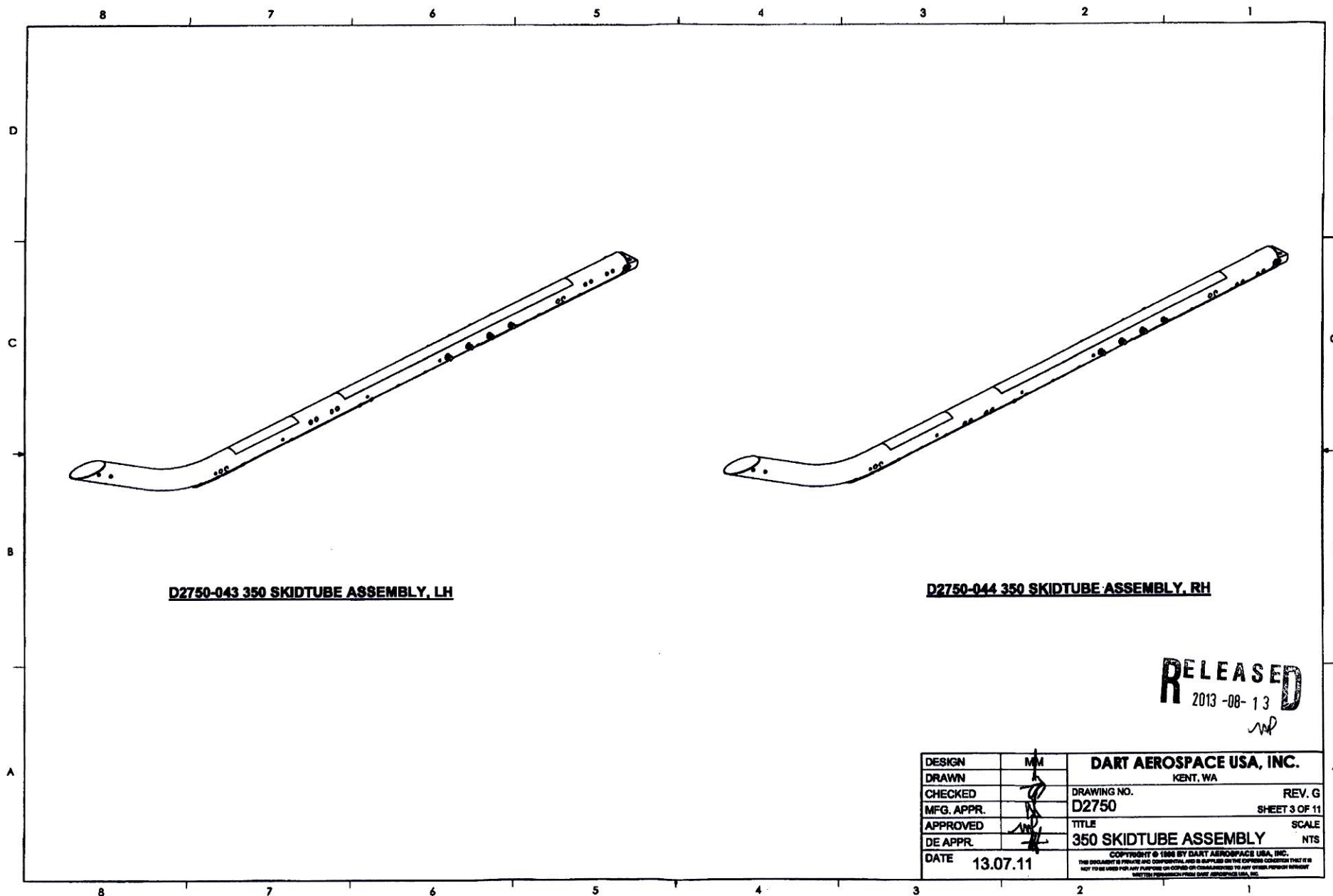
D2750-041 350 SKIDTUBE ASSEMBLY, LH



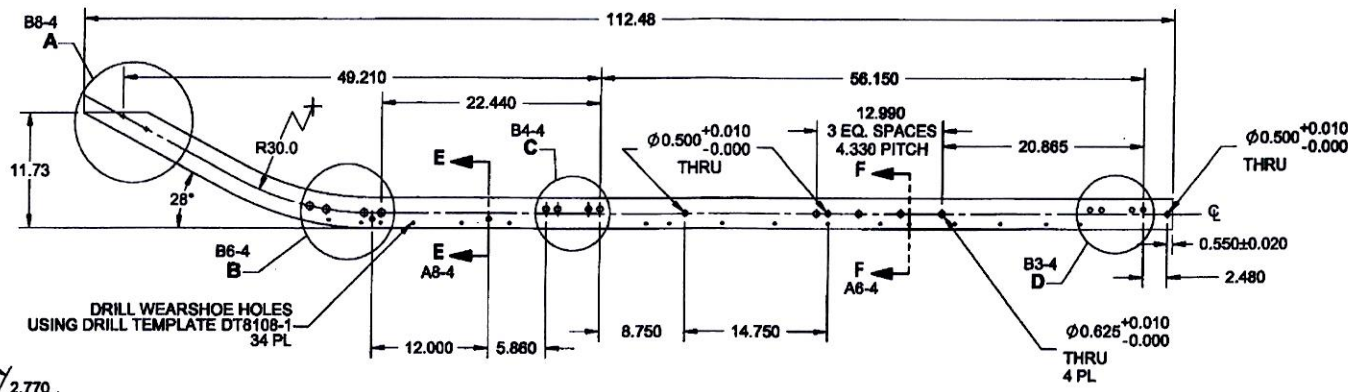
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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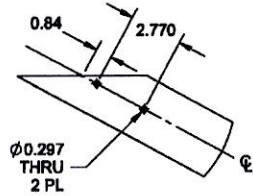
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CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 2 OF 11	
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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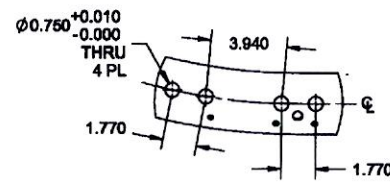
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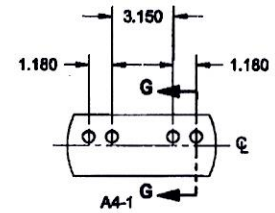
D2750-1 LH SKIDTUBE



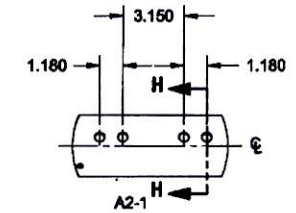
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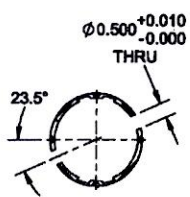
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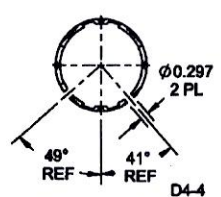
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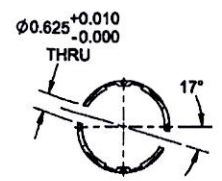
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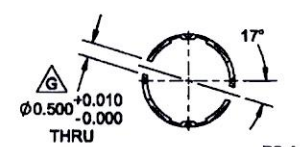
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



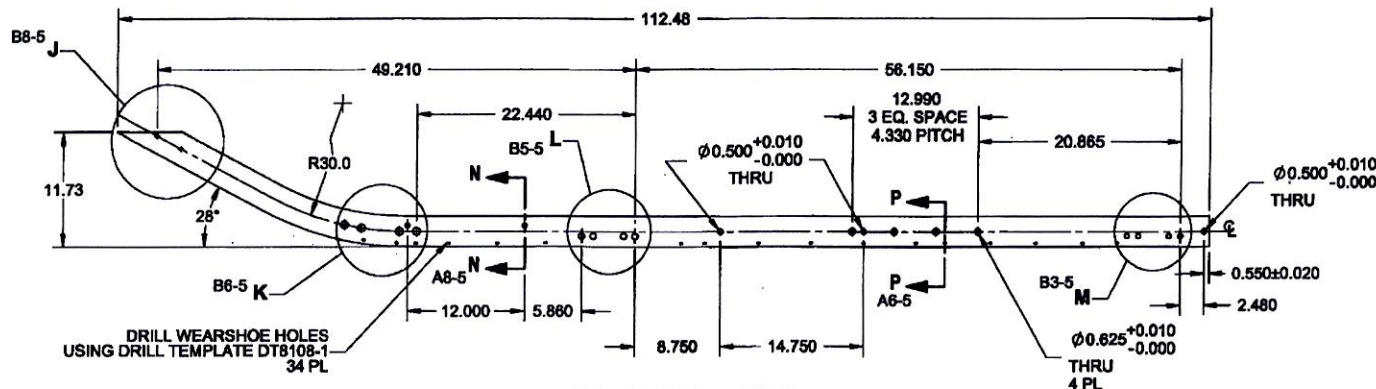
SECTION G-G
SCALE 3X, 4 PL



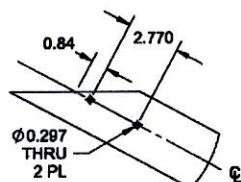
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SCALE 3X, 4 PL

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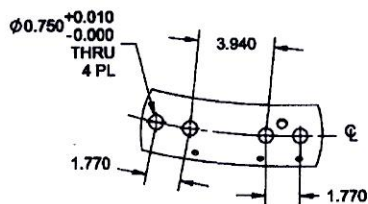
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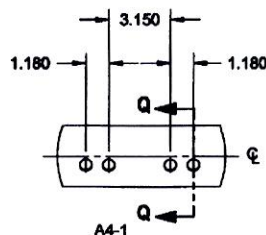
D2750-2 RH SKIDTUBE



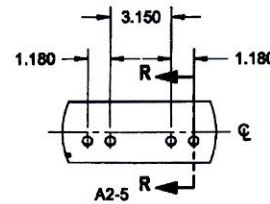
DETAIL J
D8-5
SCALE 2X



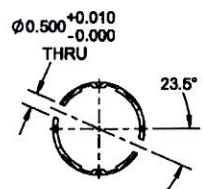
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SCALE 2X



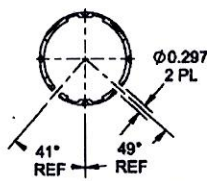
DETAIL L
D6-5
SCALE 2X



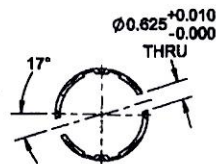
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C3-5
SCALE 2X



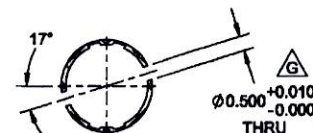
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C6-5
SCALE 3X, 2 PL



SECTION P-P
C4-5
SCALE 3X, 17 PL



SECTION Q-Q
B5-5
SCALE 3X, 4 PL



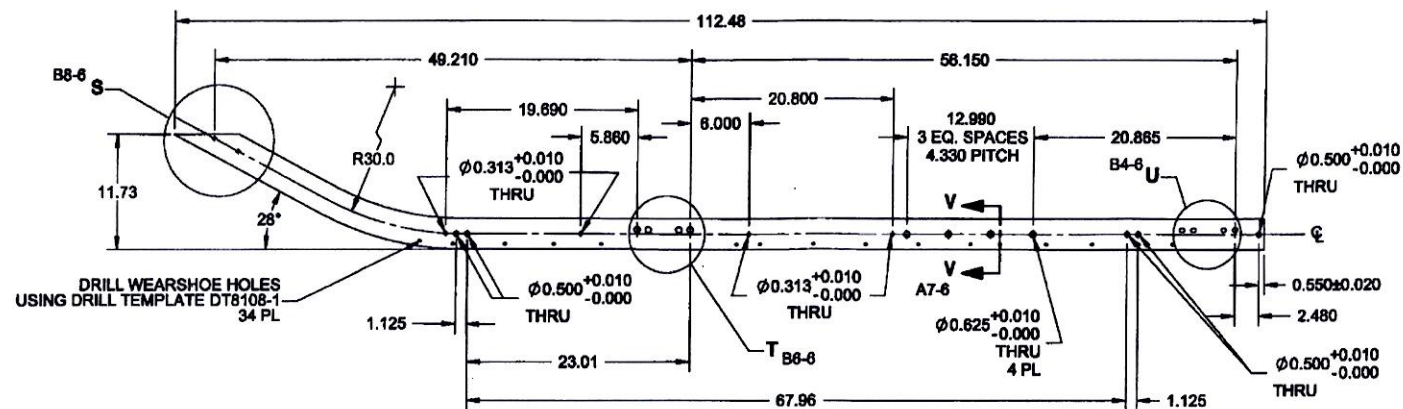
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B3-5
SCALE 3X, 4 PL

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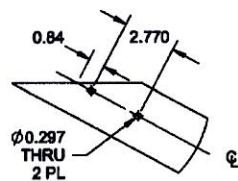
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DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

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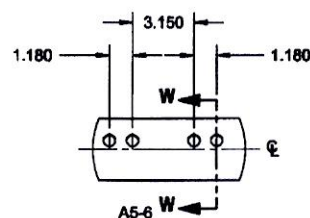
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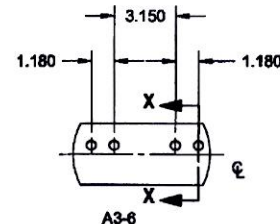
D2750-3 LH SKIDTUBE



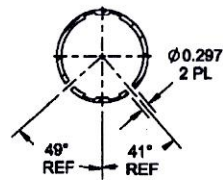
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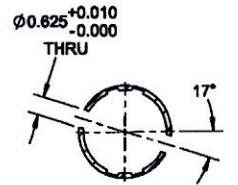
DETAIL T
SCALE 2X



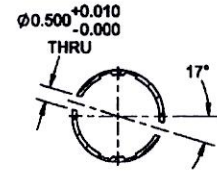
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

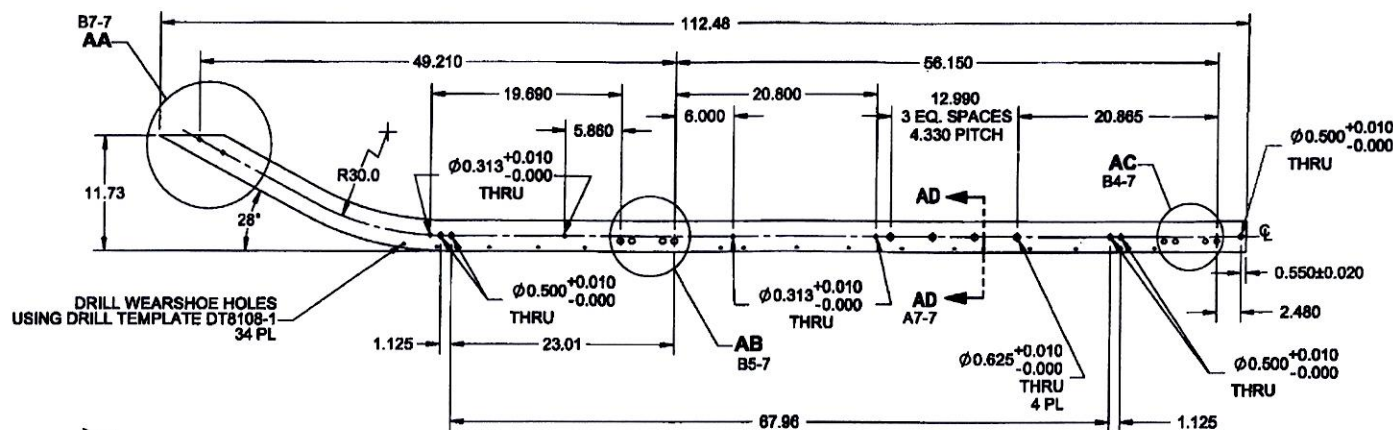


SECTION X-X
SCALE 3X, 4 PL

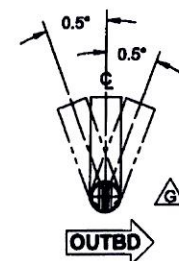
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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 8 OF 11	
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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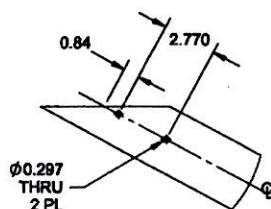
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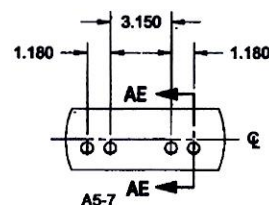
D2750-4 RH SKIDTUBE



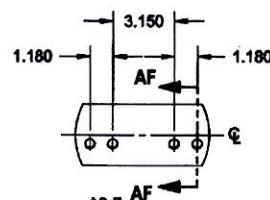
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



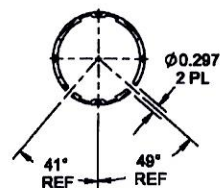
DETAIL AA
SCALE 2X



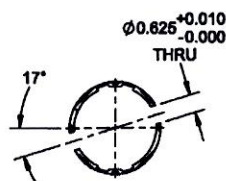
DETAIL AB
SCALE 2X



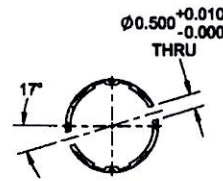
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

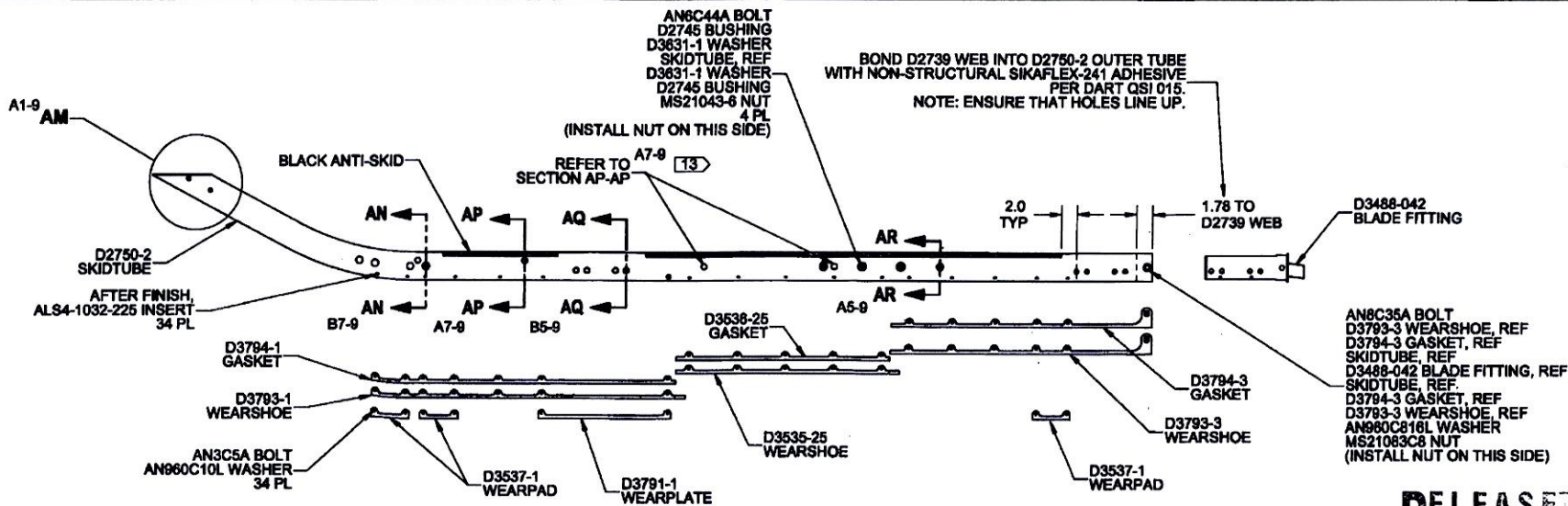


SECTION AF-AF
SCALE 3X, 4 PL

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2013-08-13

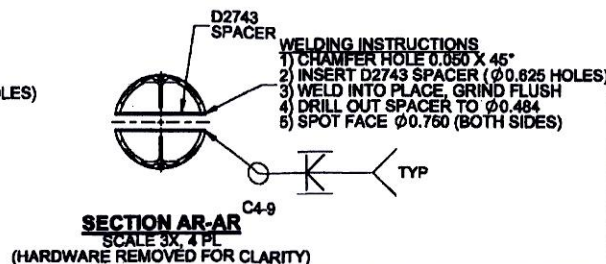
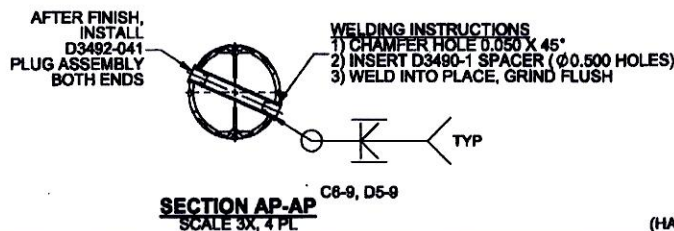
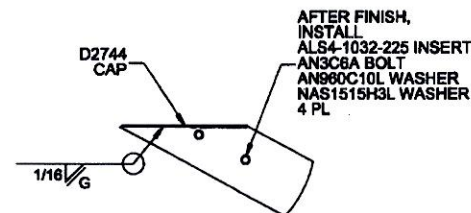
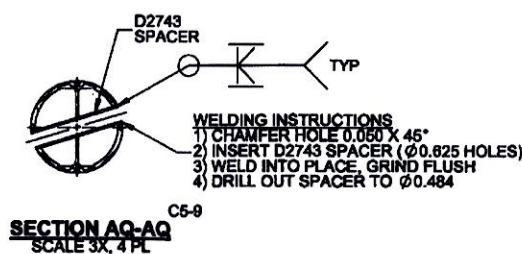
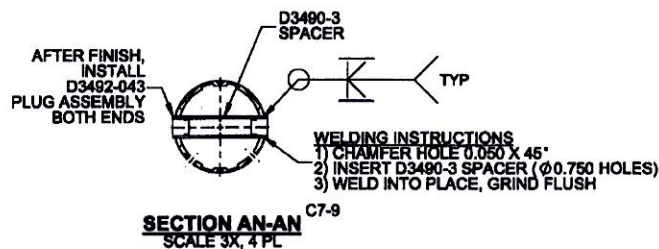
DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 7 OF 11
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8 7 6 5 4 3 2 1

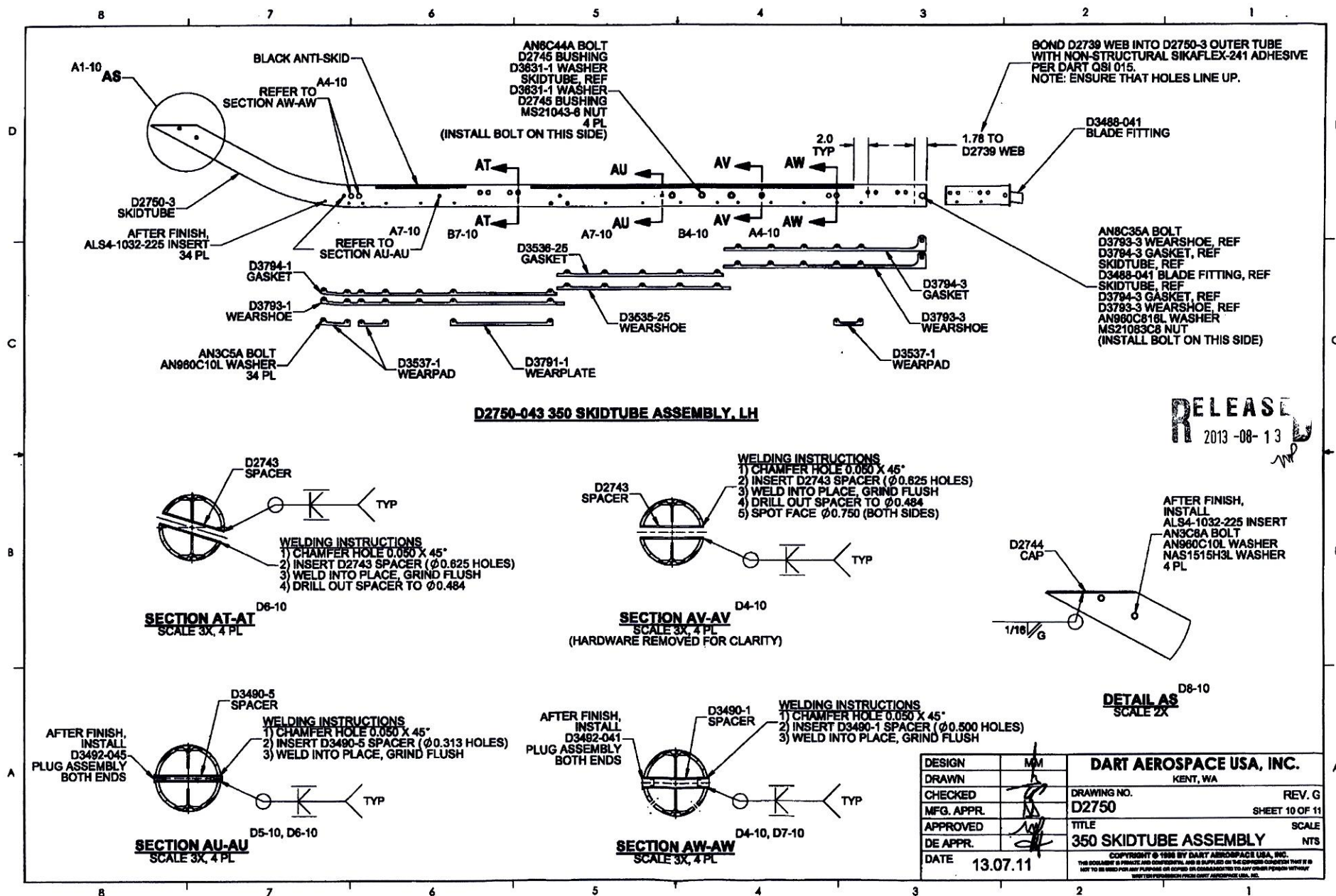


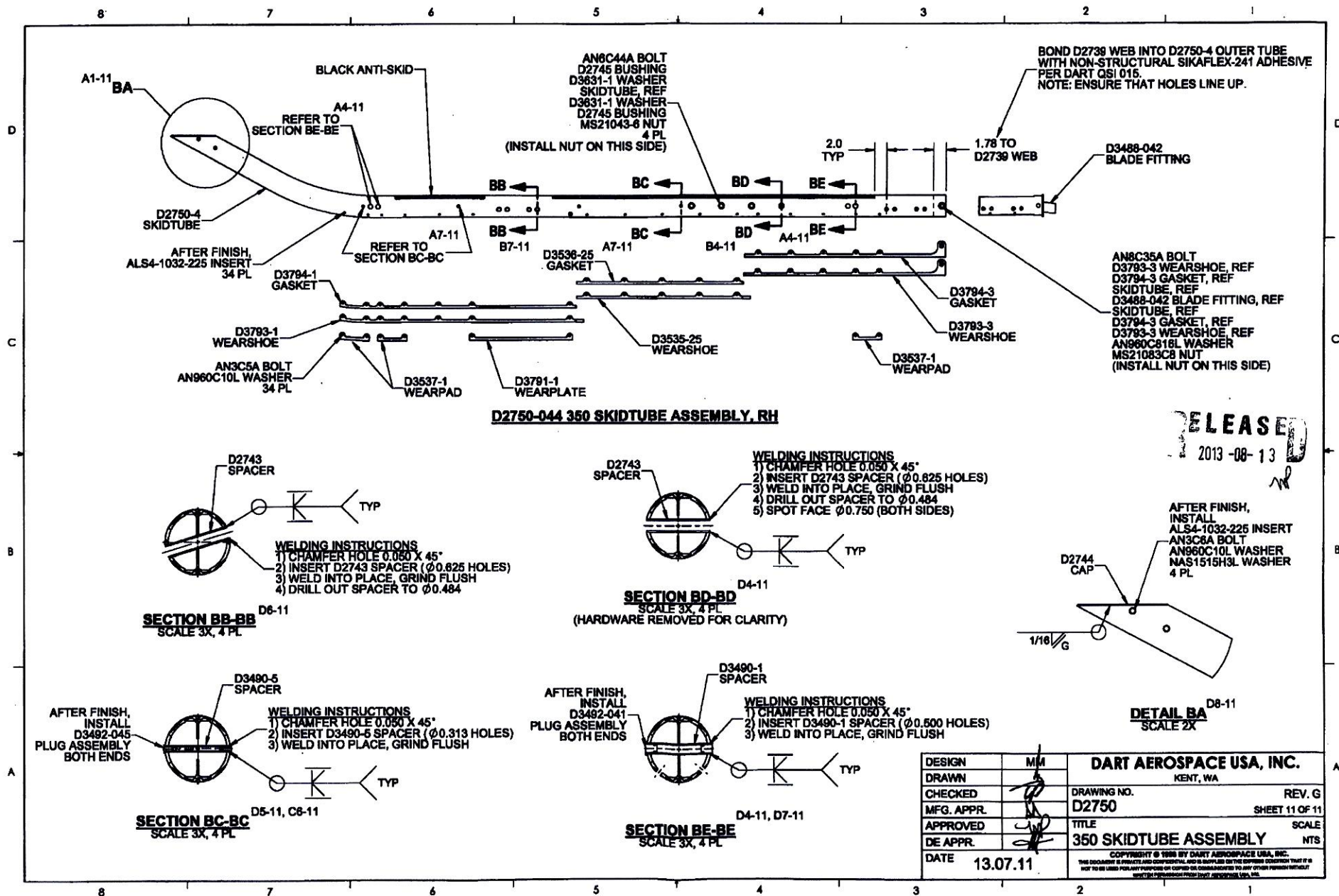
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13



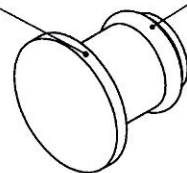
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
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D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

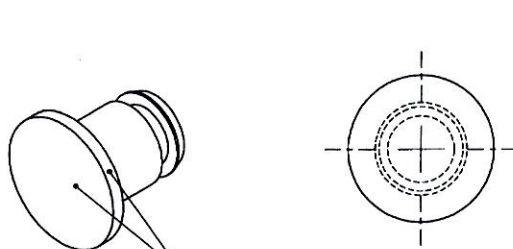
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:

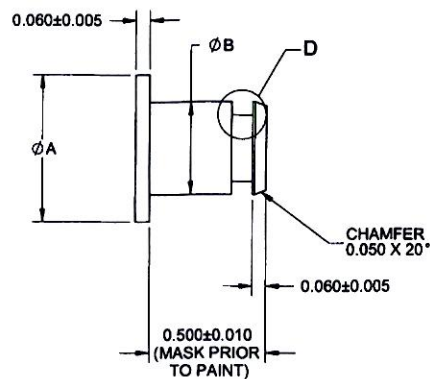
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

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11 2013-11-13

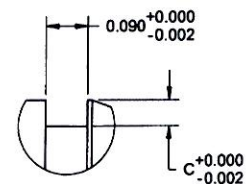
E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055, (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>ALS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>AP</i>	D3492	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	PLUG	NTS
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POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

△

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. E
MFG. APPR.	DS	D3492	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	PLUG	4:1
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RELEASED
2013-11-13

Work Order ID 163172

Thursday, June 22, 2017 10:20:22 AM

163172

Page 1

Item ID: D350-636-012

Accept

N900040100

Revision ID:

Setup Start ***NS1***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop ***NS2***Start Date: 6/22/2017 Start Qty: 1.00 ***1***Required Date: 7/5/2017 Req'd Qty: 1.00 ***1***

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date: JUN 22 2017 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750-042

G

D3492

E

AUG 11 2017

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc Control -USB or Paperwork

record fwd angle

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
5
9-89

AUG 15 2017